

Work Order ID 160950

Friday, May 05, 2017 10:21:18 AM

160950

Page 1

Item ID: PB67-43001-197W

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Outer Tube Weldment

Start Date: 5/11/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/15/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan:

DAS

21

Date:

MAY 05 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	D								

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

~~Memo~~

1.01

1- Cut to length as per dwg

2- Deburr

0.00

110

110

Mtl Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

~~Memo~~

2.42

1- Drill holes end holes using DT8792

2- Mill slot

3- Drill .125" holes

4- Deburr

0.00

120

120

QC

Quality Control

~~Memo~~

0.00

QC5- Inspect part completeness to step on W/O

QC6

20

7

MAY 23 2017

DAS

13

9-89

7x80176-7

7

DAS

38

9-89

JUN 08 2017

perch. issue P/O meter machines pending. P/O: 36405

used + inspect attached c/c to w/o

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Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>131562</u> Large Fab	0.00				<u>7</u>	<u>JUN 09 2017</u>		<u>DAS</u> <u>24</u> <u>9-89</u>
	Memo	0.00							
Large Fab	1- Weld end cap as per dwg PB67-43001 2- Grind end cap flush								
140 *140* QC	QC10- Inspect visual per QSI004- ground welds	0.00				<u>①</u>	<u>17.06.12</u>		<u>DAS</u> <u>9</u> <u>9-89</u>
Quality Control	Memo	0.00							
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00				<u>①</u>	<u>17.06.12</u>		<u>DAS</u> <u>9</u> <u>9-89</u>
Quality Control	Memo	0.00							

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7

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: WA3	0.00				7	JUN 12 2017		DAS 24 9-89
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							17/6/13 dg
170									
QC	Memo	0.00							
Quality Control									



JUN 12 2017

Picklist Print

Friday, May 05, 2017 10:21:18 AM

Page 1
7

Work Order ID: 160950

160950

Parent Item: PB67-43001-197W

PB67-43001-197W

Parent Item Name: Outer Tube Weldment

Start Date: 5/11/2017

Required Date: 5/15/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 15.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	50.3690	4.1775	30.78158			DAS 13 9-89
M6061T6T1 750W 065									**			MAY 23 2017	
6061T6 RDTUBE 1.750 X 0.65W													

Location	Loc Qty	Loc Code
MAT016	50.369	
M133700	7.681	
M136283	42.688	

PB67-43001-199

Manufactured No

PB67-43001-199

Outer Tube End Cap

130 Each

4.0000

1

**

7 JUN 08 2017

DAS
24
9-89

Location	Loc Qty	Loc Code
Mezz2	4	
142940	4	

B 160958 → 7

ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-197W	OUTER TUBE WELDMENT
1	1	B67-43001-197	OUTER TUBE
2	1	B67-43001-199	END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160950 MJS 1705-d

B67-43001-197 OUTER TUBE

B67-43001-199 END CAP

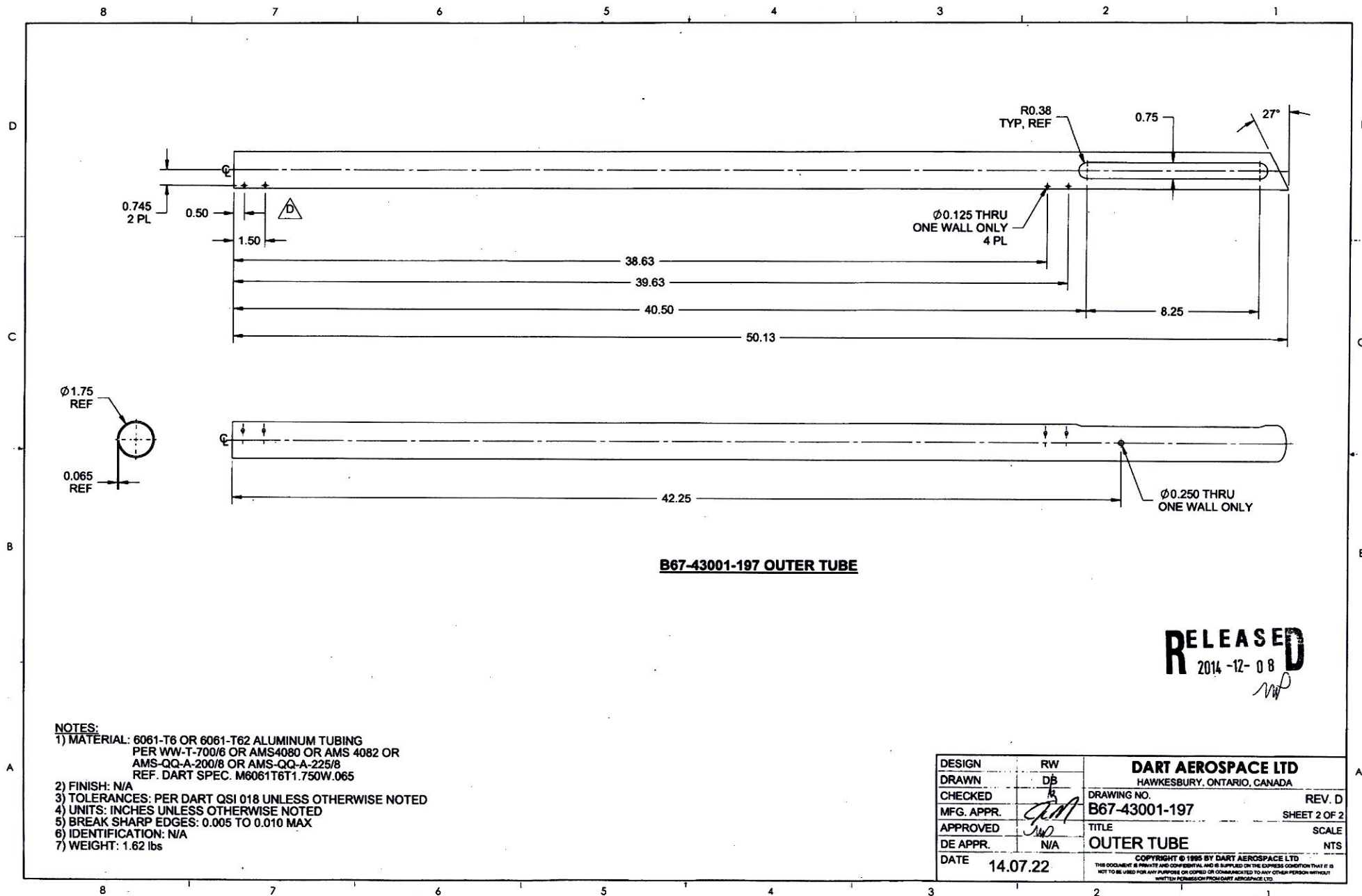
 **B67-43001-197W OUTER TUBE WELDMENT**

RELEASE
2014-12-08
WJS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.66 lbs
- 8) WELDING: PER DART QSI 004

REV	DESCRIPTION	BY	DATE
D	ADD -197W WELDMENT (SH 1), MOVE HOLE LOCATION (ZN C7-2). REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.27
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-197 TITLE OUTER TUBE SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	N/A		
DATE	14.07.22		





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36405

Purchase Order Date 5/23/2017

PO Print Date 6/5/2017

Page Number 3 of 5

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

Line Total: \$138.95

6 160815 PB67-43001-259 INNER TUBE 6/5/2017 Yes 6/5/2017

7.00 \$19.85 \$138.95

MACHINE AS PER DWG PB67-43001-259
MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541

Line Total: \$138.95

7 160917 PB67-43001-285 UPPER TUBE 6/16/2017 Yes 6/16/2017

5.00 \$0.00 \$0.00

MACHINE AS PER DWG PB67-43001-285
MATERIAL 6061-T6 ROUND TUBING 1.500" X .125" WALL M133966,M135028

Line Total: \$0.00

8 160950 PB67-43001-197 OUTER TUBE 6/16/2017 Yes 6/16/2017

7.00 \$0.00 \$0.00

MACHINE AS PER DWG PB67-43001-197
MATERIAL 6061-T6 ROUND TUBING 1.750" X 0.065" WALL M137541

DAE
38
9-88

Note:

6/5/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21723
Date: Jun 06, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36405	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jun 06, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5159-3 Seat Rib, as per drawing D5159-3 Rev. A	Each	6	6	
PB67-43001-127 Handle Arm, as per drawing PB67-43001-127	Each	5		
PB67-43001-257 Inner Tube, as per drawing PB67-43001-257	Each	7		
PB67-43001-247 Inner Tube, as per drawing PB67-43001-247	Each	6		
PB67-43001-255 Inner Tube, as per drawing PB67-43001-255	Each	7		
PB67-43001-259 Inner Tube, as per drawing PB67-43001-259	Each	7		
PB67-43001-285 Upper Tube, as per drawing PB67-43001-285 *** please note that 1 piece has an extra hole in wrong position (marked red) ***	Each	5	5	
PB67-43001-197 Outer Tube, as per drawing PB67-43001-197	Each	7	7	
PB67-43001-229 Outer Tube, as per drawing PB67-43001-229	Each	7	7	
PB67-43001-235 Outer Tube, as per drawing PB67-43001-235	Each	7	7	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SP H-67</u>		Thank you for your order!		

DA6
38
9-89



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

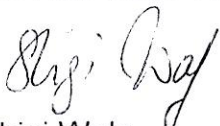
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
6	D5159-3	Seat Rib	SS304 square tubing 0.750" x .049" wall M137401	36405
5	PB67-43001-285	Upper Tube	6061-T6 round tubing 1.500" x .125" wall M133966, M135028	36405
7	PB67-43001-197	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405
7	PB67-43001-229	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405
7	PB67-43001-235	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 6, 2017